

Date: Tuesday, 27/01/2009 11:09:31 AM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: MOUNTING ANGLE		
Job Number	45243					
Estimate Number	10509					
P.O. Number						
This Issue	27/01/2009	S.O. No.		Part Number	: D2564	
Prsht Rev.	NC			Drawing Number	: D2564 REV. B1	
First Issue	27/01/2009	Type	MACHINED PARTS	Project Number	: N/A	
Previous Run	40936			Drawing Revision	: B1	
Written By				Material	:	
Checked & Approved By				Due Date	12/02/2009	Qty: 40 Um: Each
Comment	: Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6207	Angle Extrusion	
		Comment: Qty.: 0.0962 f(s)/Unit Total : 3.8472 f(s) Angle Extrusion Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8) (D6207) Batch: B41418	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA276 Rev: B & Dwg D2564 Rev: B	
		2-Deburr if necessary	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:09:32 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: MOUNTING ANGLE
Job Number: 45243		Part Number: D2564
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1 	PACKAGING RESOURCE #1  40x
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>Pat</i> 9/1/2009 <i>Self</i>		
7.0	QC21 	FINAL INSPECTION/W/O RELEASE  09/02/029A
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>MF</i> <i>09-02-02</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	W5243
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

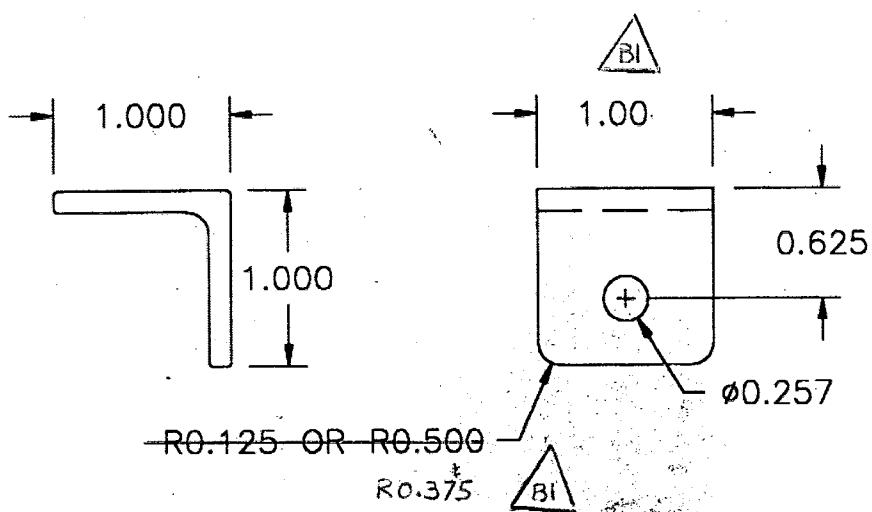
Measured by:	J. A	Audited by:	JL	Prototype Approval:	N/A
Date:	09/01/28	Date:	09/01/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue	KJ/JLM	JM

DART

DRAFT COPY/IS-AUG-96

DESIGN MIKE M	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2564	REV. B SHEET 1 OF 1
DATE 96:04:30		TITLE MOUNTING ANGLE	SCALE 1:1
B	97:05:06	MODIFIED DIMENSIONS	
BI	RF 02.09.17	R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000	

RELEASED
(97/05/06 BW)NOTES:

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. HS243

